

Date: Tuesday, 4/24/2007 3:23:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 32048 -2	
Estimate Number : 12405	
P.O. Number : N/A	Part Number : D346720
This Issue : 4/24/2007 S.O. No. : N/A	Drawing Number : D3467 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 28584	Material : N/A
	Due Date : 5/8/2007
Written By : _____	Qty: 2 Um: Each
Checked & Approved By : <u>4/07.04.25</u>	
Comment : est rev. A 06.04.20 new issue EC	
Est Rev:B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.0776 sf(s)/Unit
 304/316 0.018 SHEET

Total: 0.1552 sf(s)

batch: M103678

ml 07 04 26

(2)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 Cut as per Dwg D3467
 Dwg Rev: B
 Prog Rev: B

ml 07 04 26

(2)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 04 26

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/04/24

(4)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

2-Form as per dwg D3467 using DT8852

mf 07-09-24

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:23:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32048 *2*

Part Number: D346720

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/02/24

①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA.*

mf

07-09-24

①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2009/04

Job Completion



2009.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

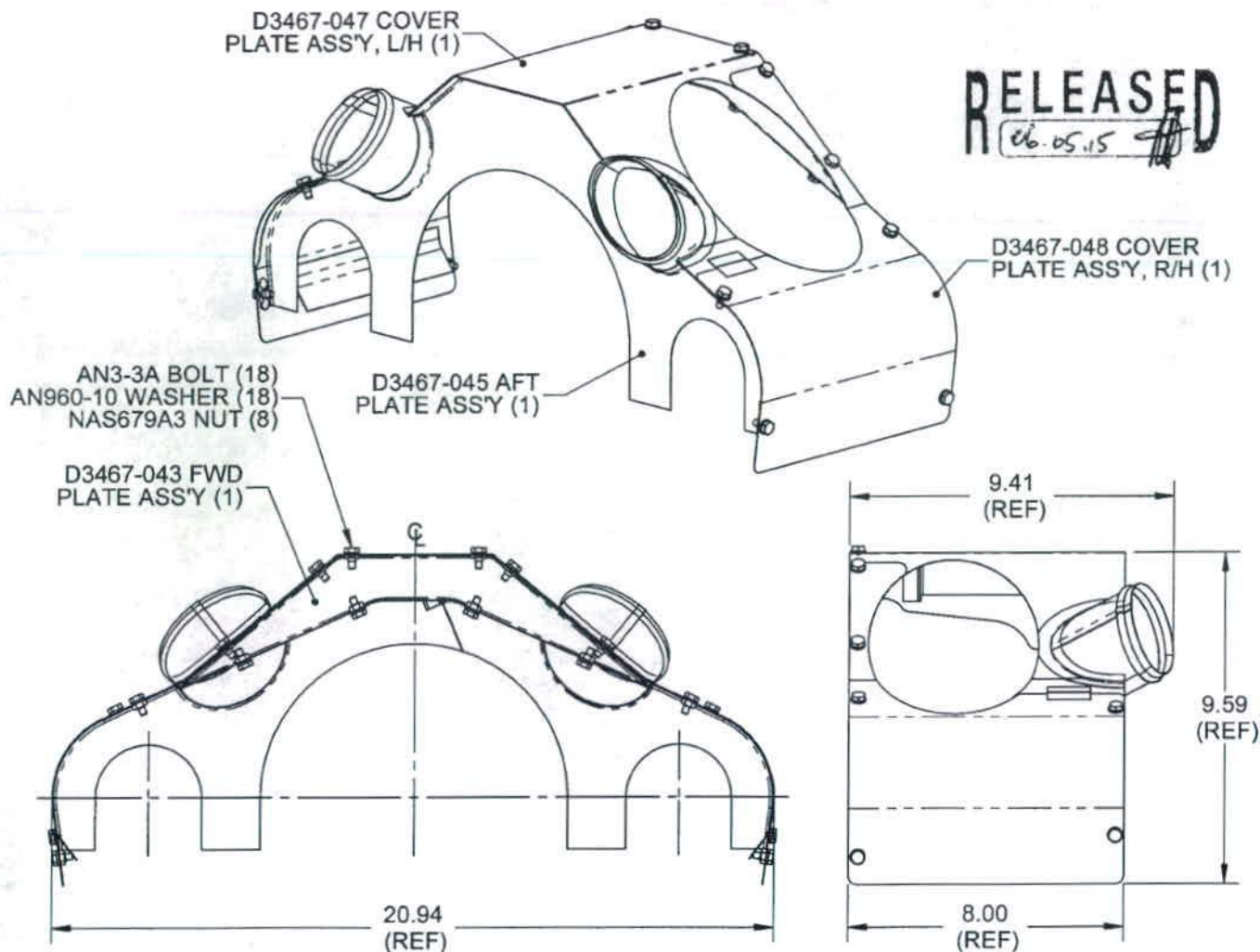
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY L/H
1	D3467-048	COVER PLATE ASSEMBLY R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

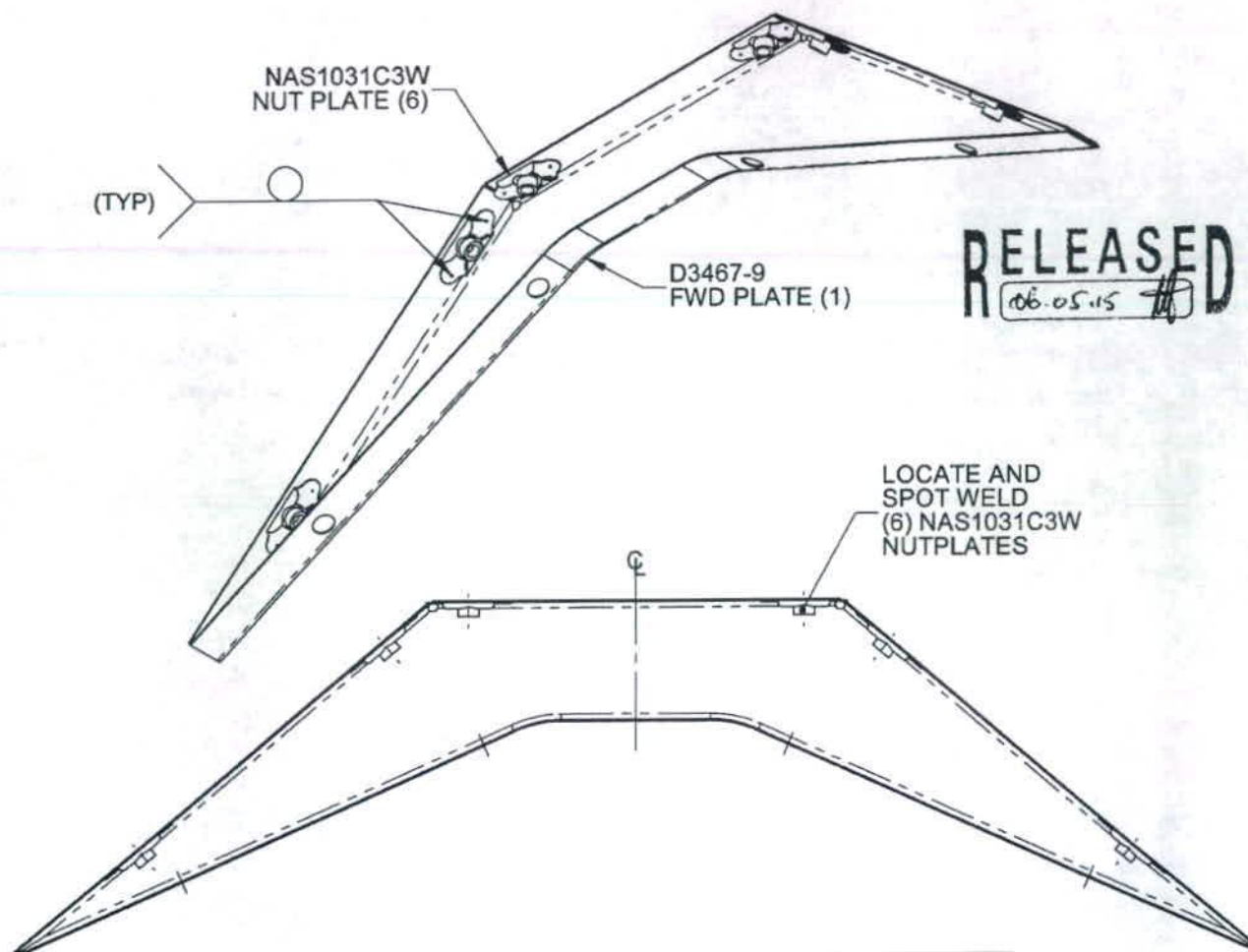
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

D3467-043 FWD PLATE ASSEMBLY**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

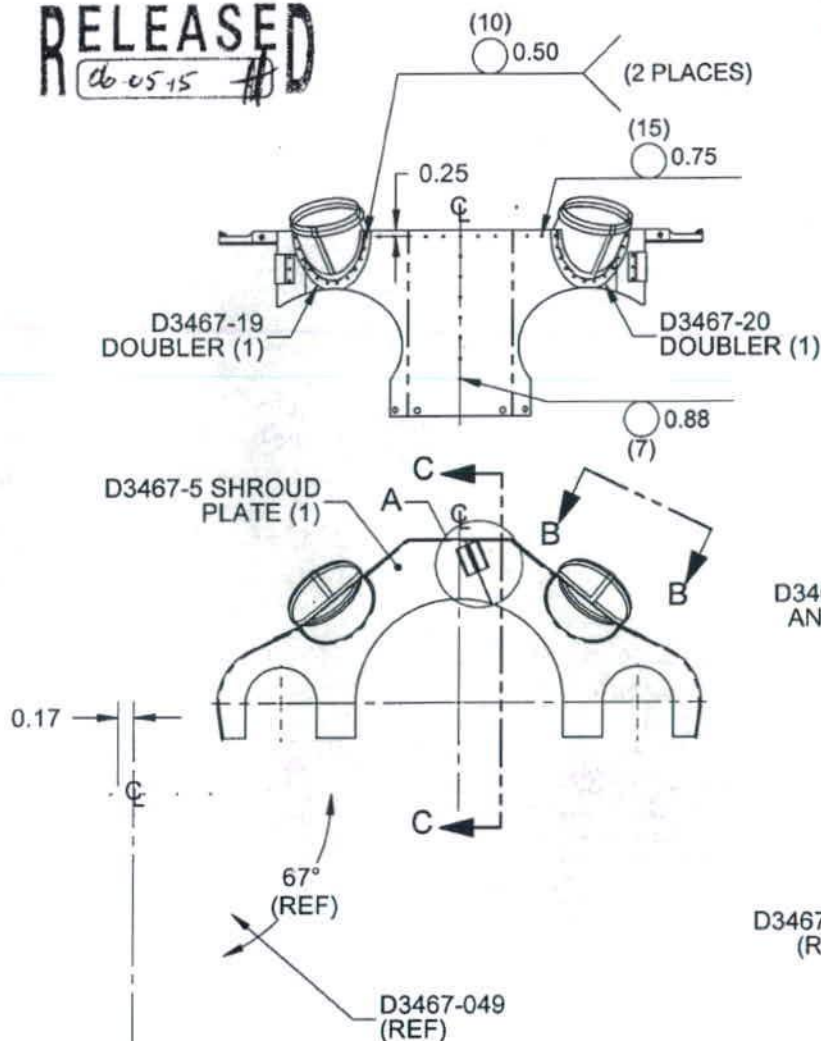
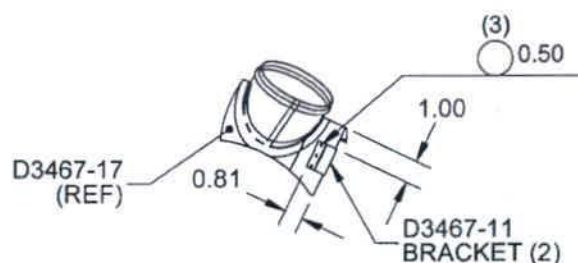
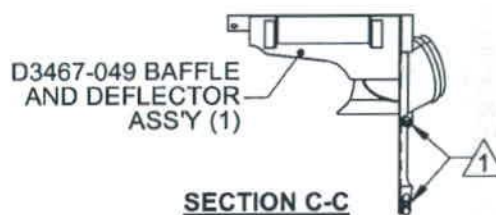
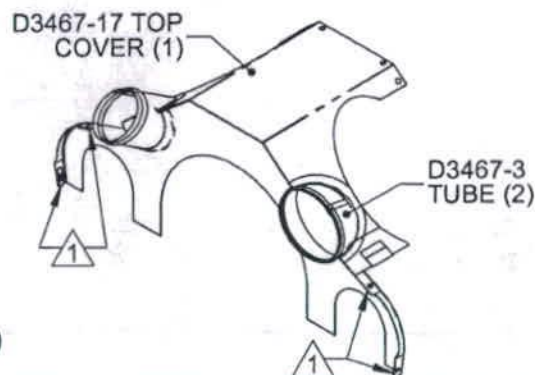
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NO. **32048**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 3 OF 15
DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:8

RELEASED
06-05-15**DETAIL A**
SCALE 1:2**VIEW B-B: WELDING D3467-11**
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE SHOP COPY
1	D3467-5	SHROUD PLATE RETURN TO
2	D3467-11	BRACKET ENGINEERING
1	D3467-17	TOP COVER UNCONTROLLED COPY
1	D3467-19	DOUBLER SUBJECT TO AMENDMENT
1	D3467-20	DOUBLER WITHOUT NOTICE
4	NAS1031C3W	NUT PLATE WORK ORDER

NO. 32048

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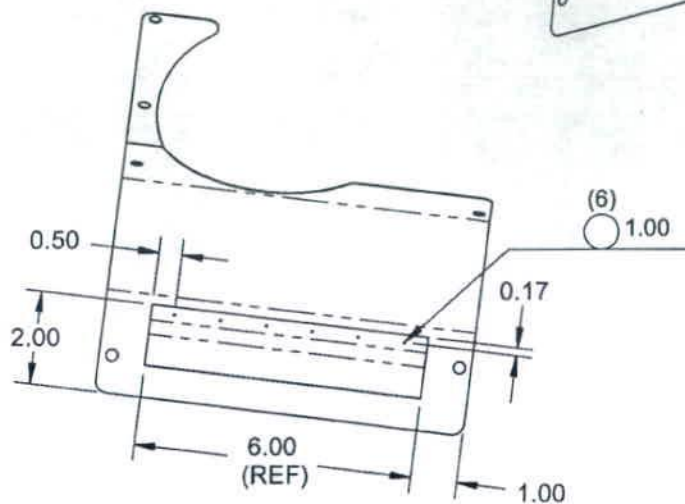
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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 4 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
06.05.15

D3467-1 COVER
PLATE L/H, SHOWN
(D3467-2 COVER
PLATE R/H, OPPOSITE)

D3467-7
SEAL STRIP (1)



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

30°
(REF) **SHOP COPY**
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NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO
0.010

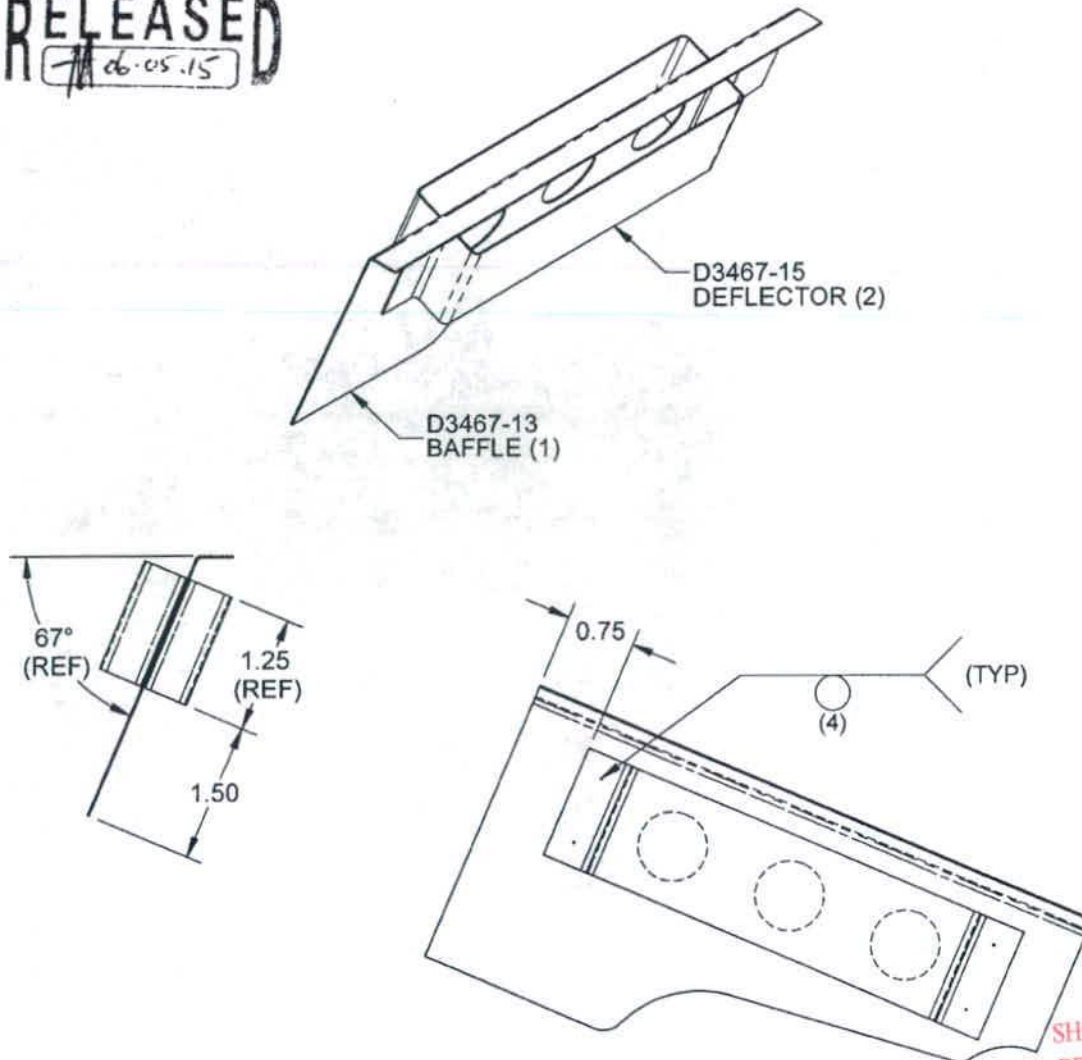
QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
06.05.15**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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NO. **32048**

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

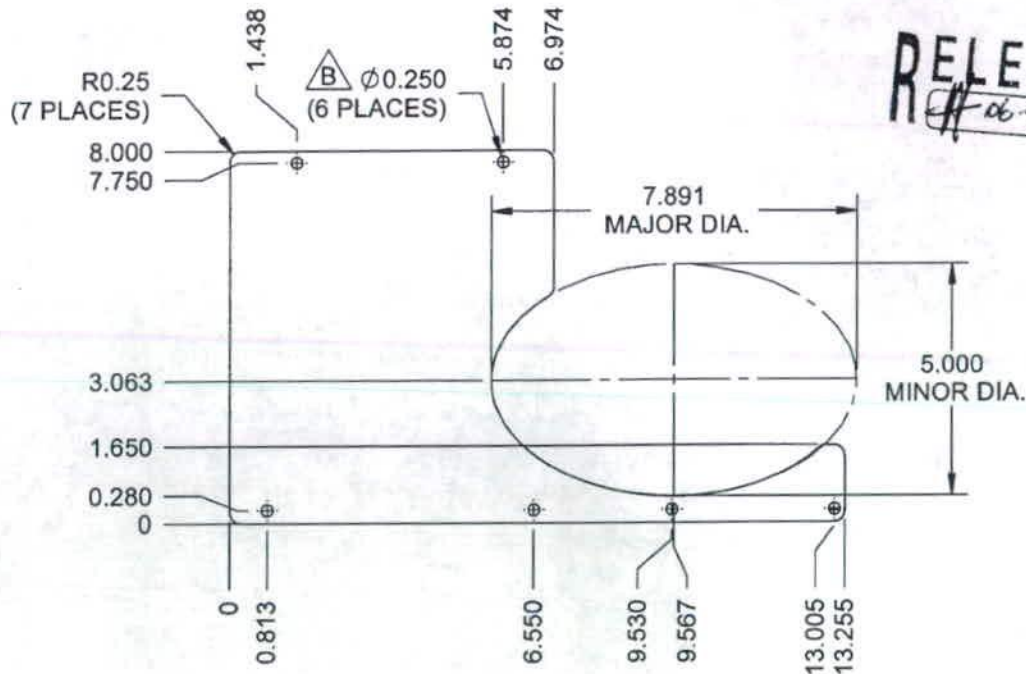
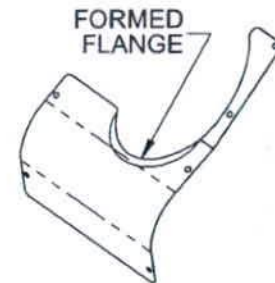
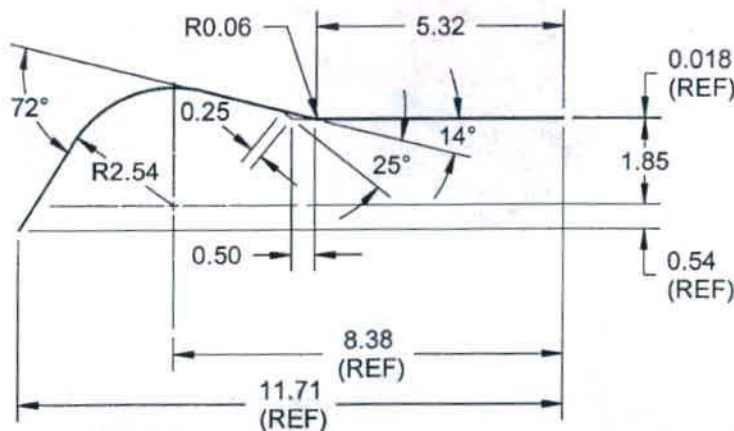
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER
PLATE ISOMETRIC VIEW,
D3467-2 R/H COVER
PLATE (OPPOSITE) COPY
SCALE 1:8****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

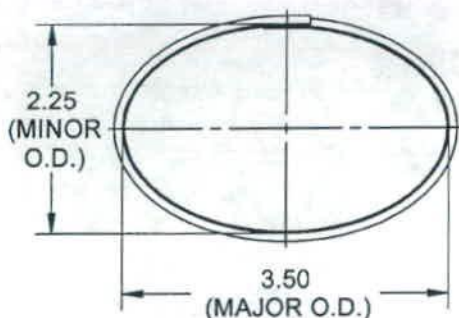
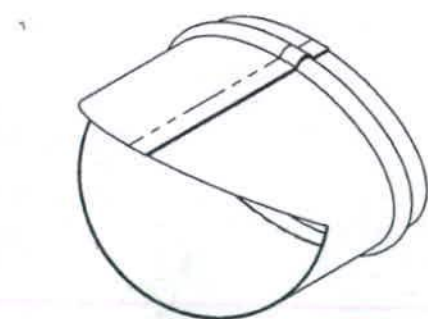
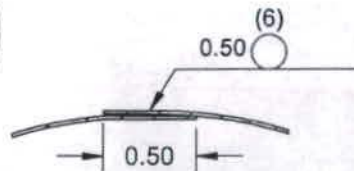
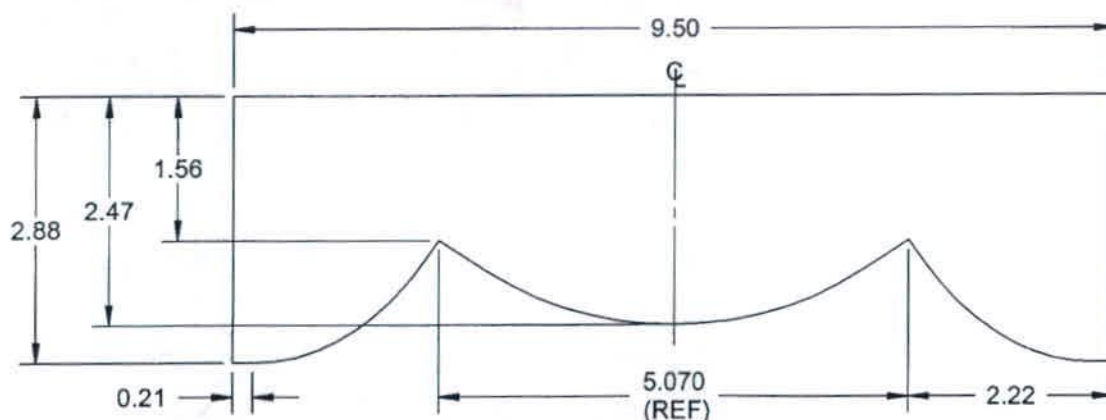
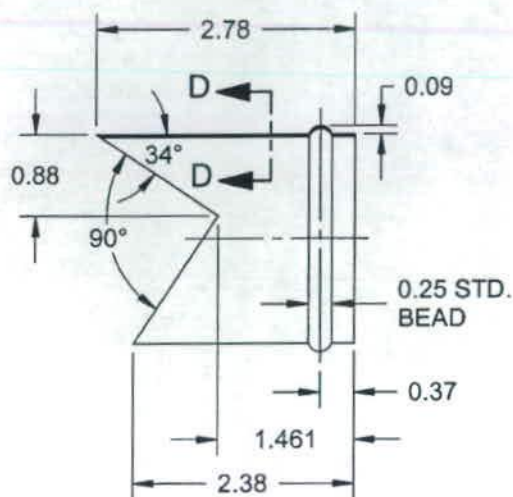
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
06.05.15**D3467-3 TUBE DETAIL****SECTION D-D**
SCALE 1:1**D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

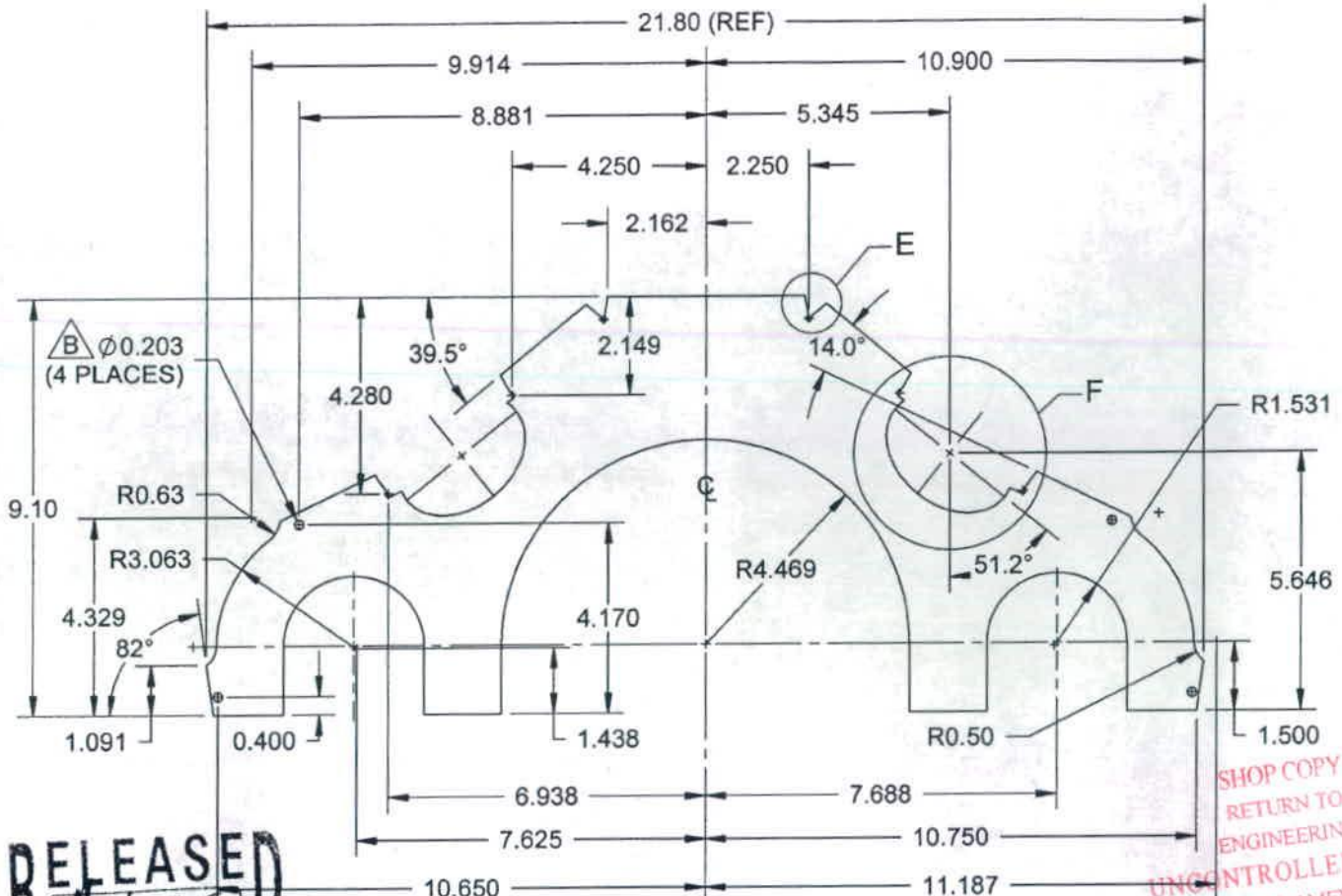
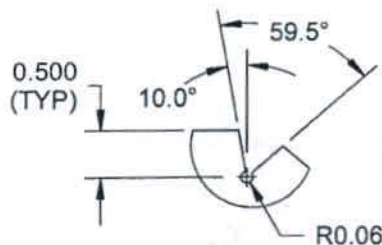
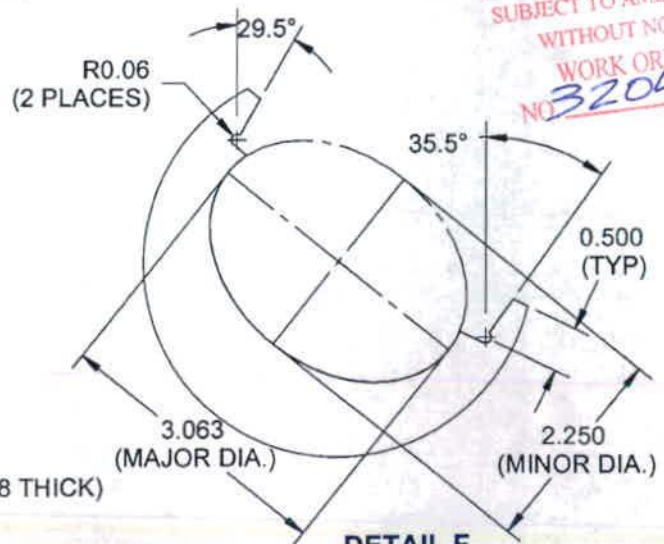
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CHECKED B	APPROVED B	DRAWING NO. D3467	REV. B SHEET 8 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8

**RELEASED**
#06-05-15**DETAIL E**
SCALE 1:2**DETAIL F**
SCALE 1:2**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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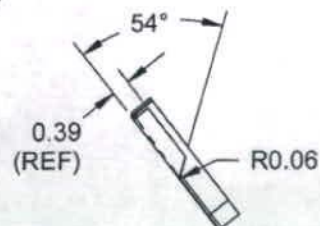
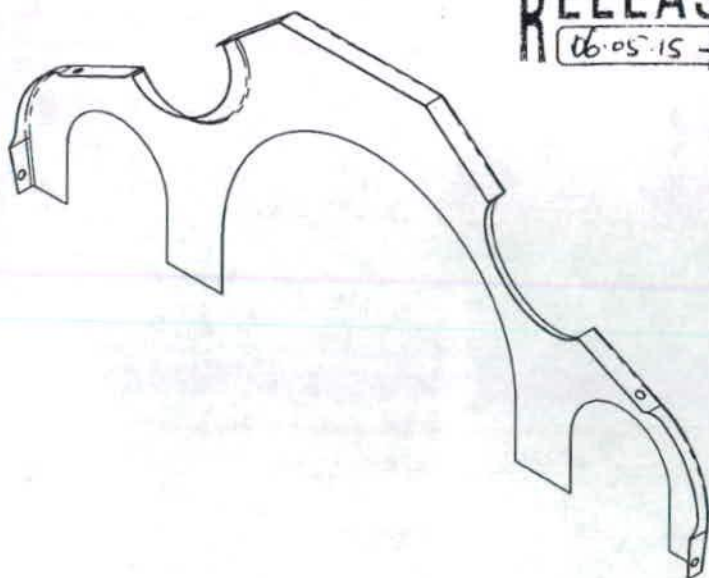
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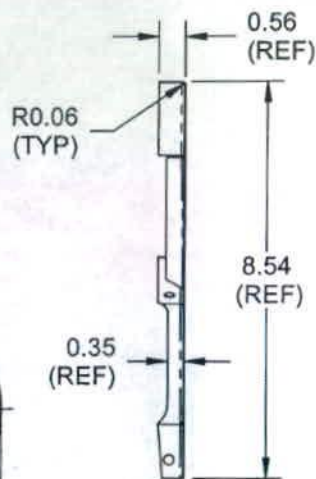
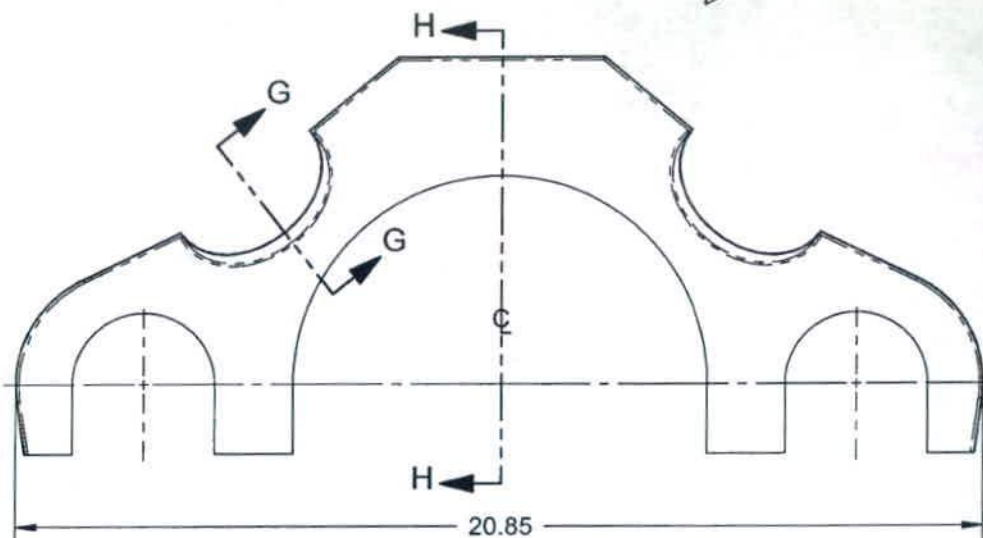


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CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3467	REV. B SHEET 9 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
06.05.15 *M*



SECTION G-G



SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

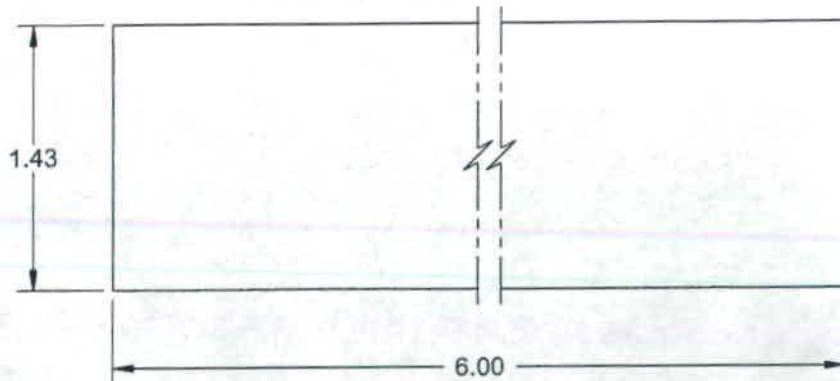
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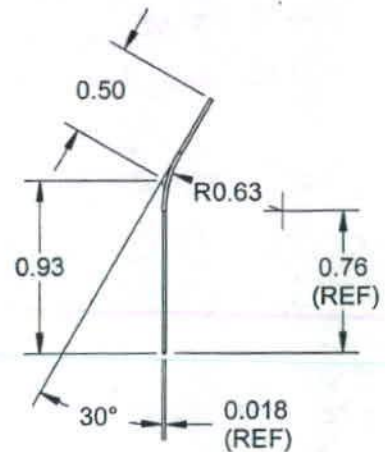
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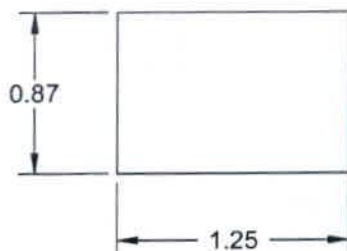
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 10 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

RELEASED
06-05-15 H

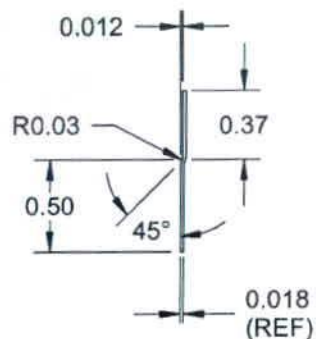
**D3467-7F SEAL STRIP
FLAT PATTERN**



**D3467-7 SEAL STRIP
BENDING DETAIL**



**D3467-11F BRACKET
FLAT PATTERN**



**D3467-11 BRACKET
JOGGLE DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

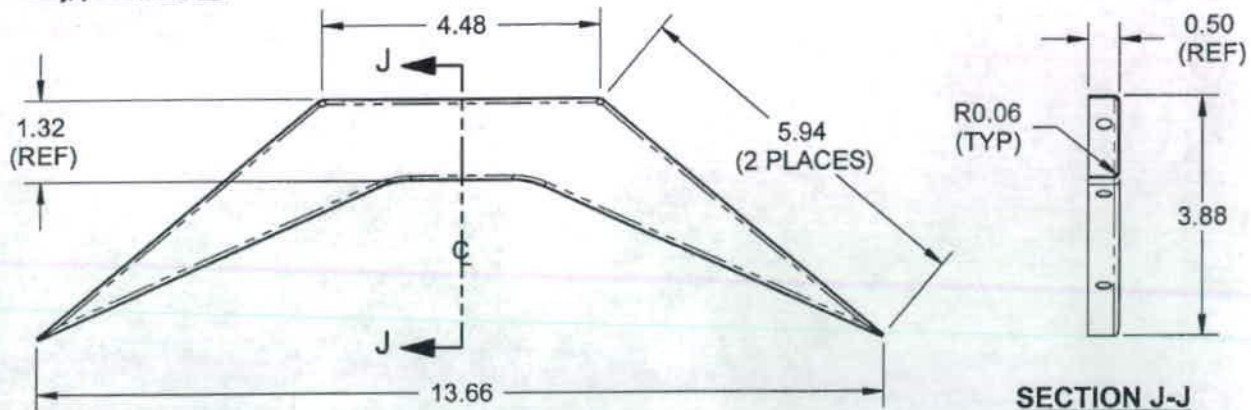
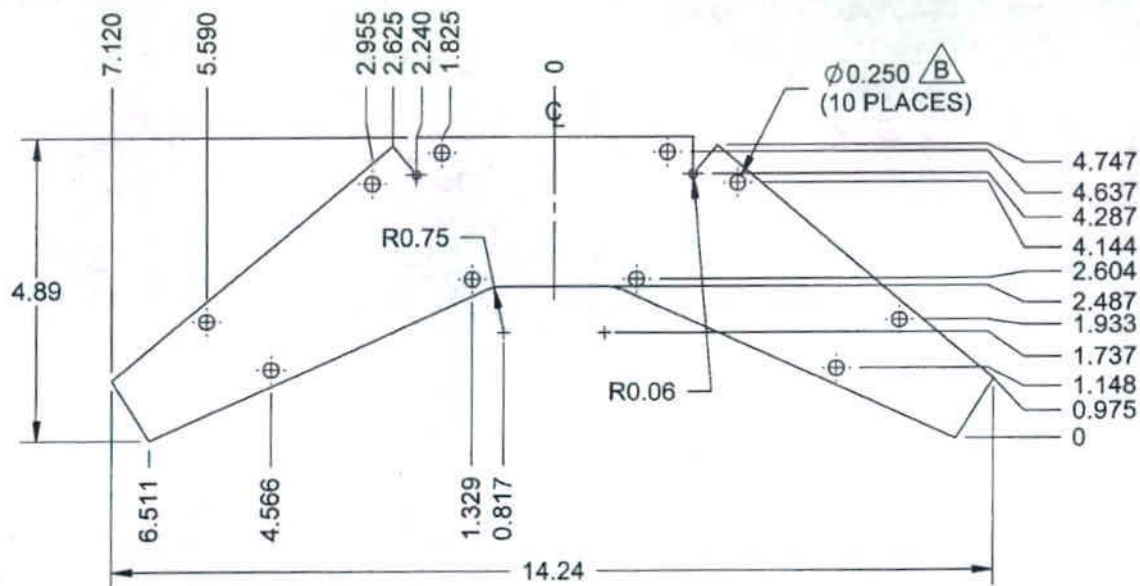
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DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3467	REV. B
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SHEET 11 OF 15 SCALE 1:3

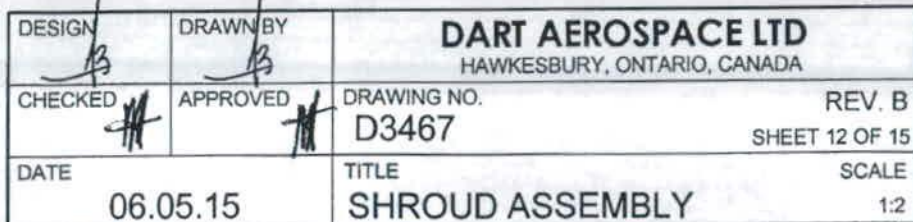
RELEASED
06.05.15**D3467-9 FWD PLATE BENDING DETAIL****D3467-9F FWD PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

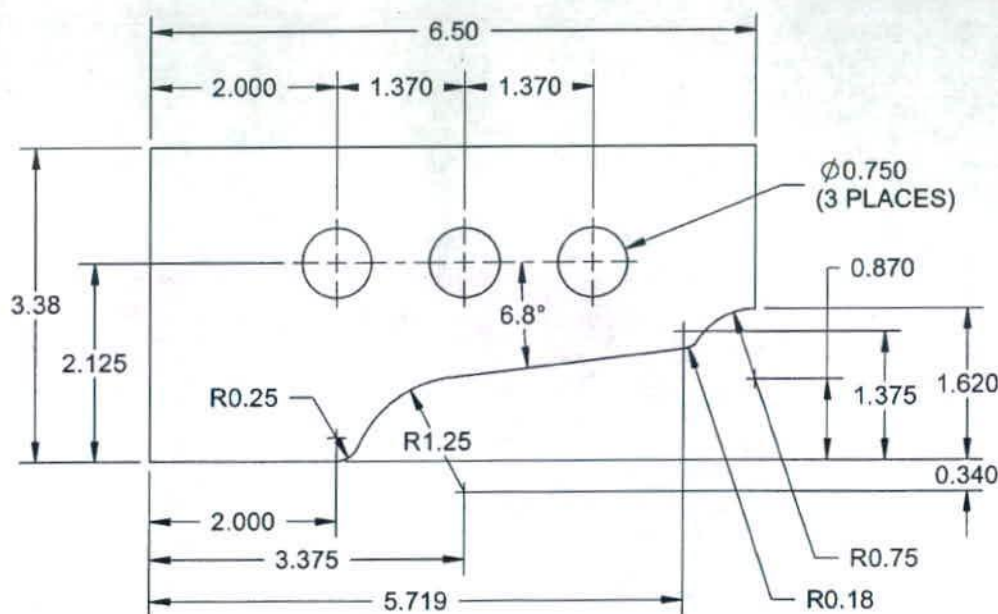
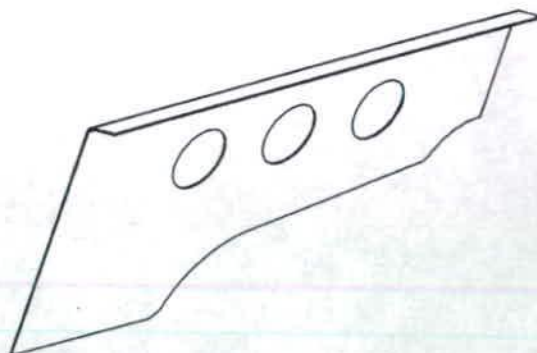
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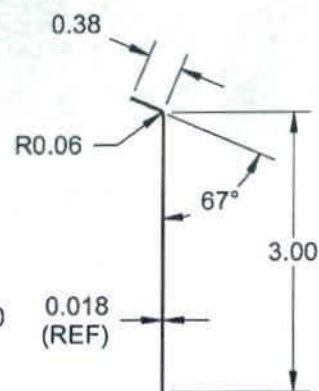
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RELEASED
66-55-15



**D3467-13F BAFFLE
FLAT PATTERN**



**D3467-13 BAFFLE
BEND DETAIL**

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

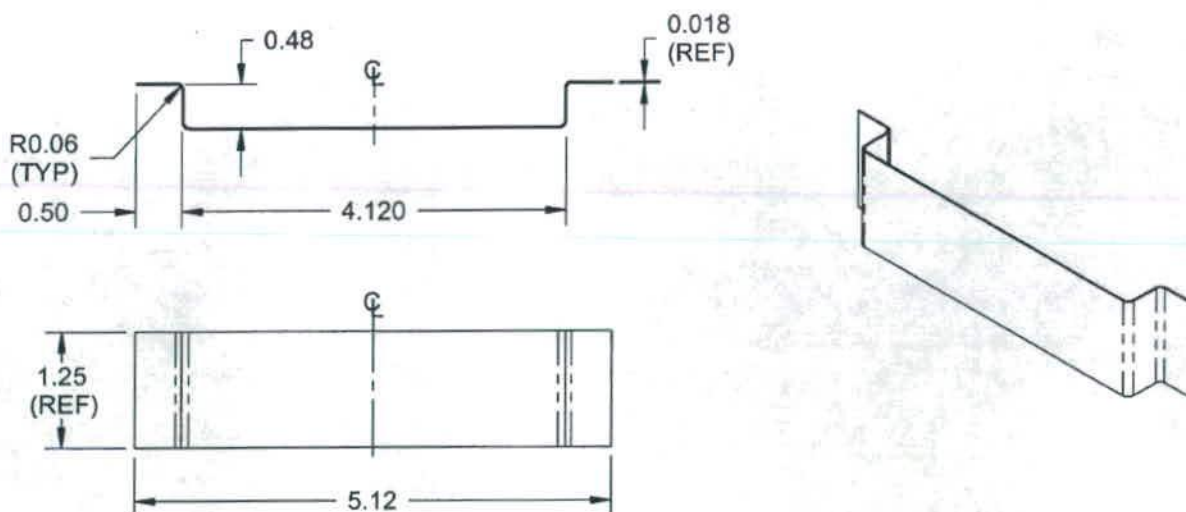
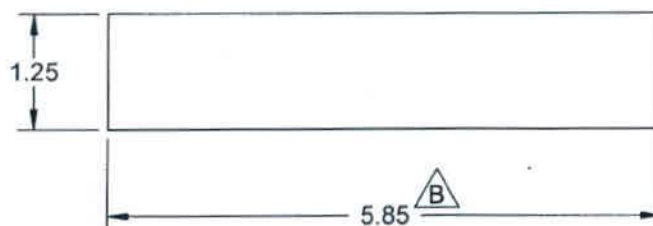
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
06.05.15**D3467-15 DEFLECTOR BENDING DETAIL****D3467-15F DEFLECTOR FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

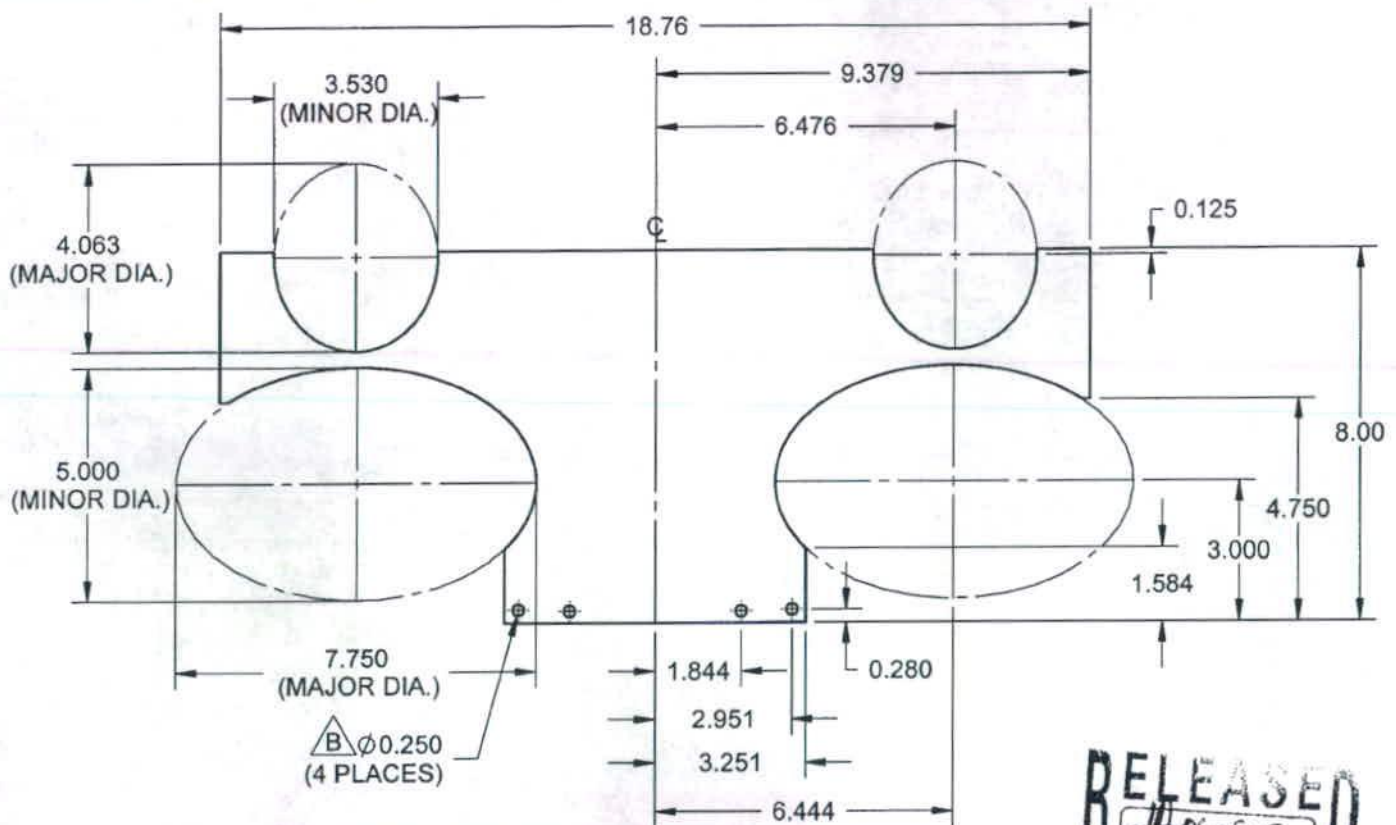
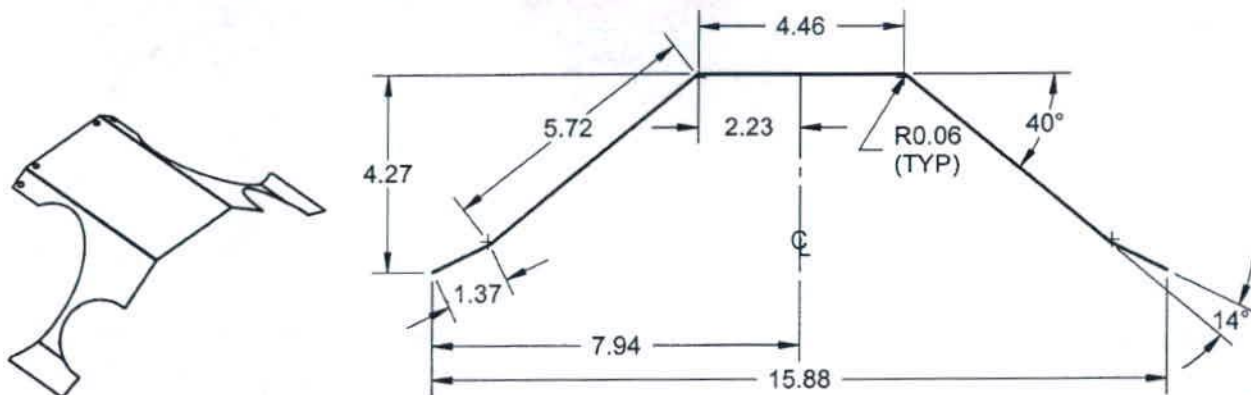
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-17F TOP COVER FLAT PATTERN****RELEASED**
#06-05-15**D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

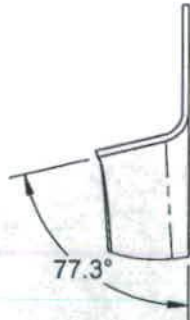
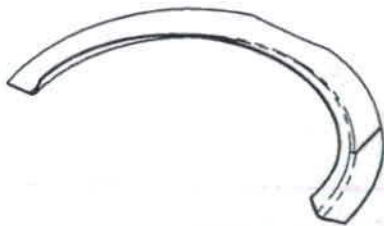
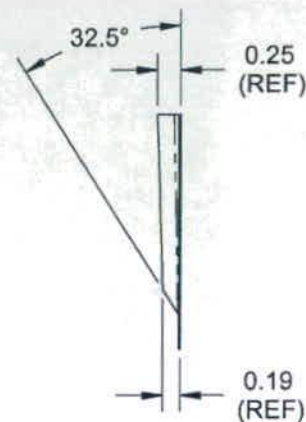
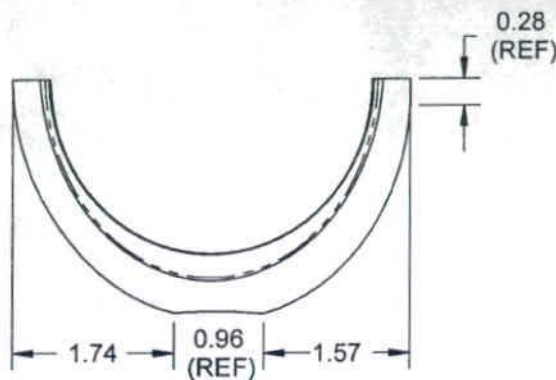
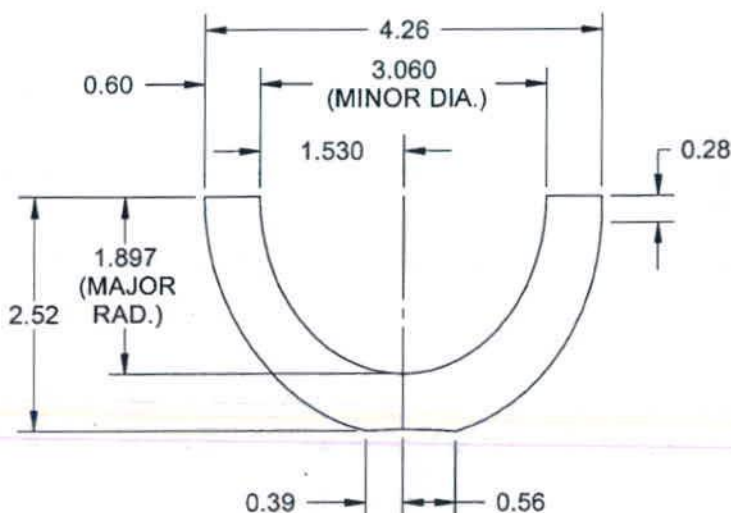
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
16 vs 15**DETAIL K**
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**
D3467-20 DOUBLER, R/H OPPOSITE

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D3467-19F FLAT PATTERN**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 32048
Description: Doubler		Part Number: D3467-20
Inspection Dwg: D3467 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.26	H-0.030	4.265	✓		V&N	
B 3.060	+/-0.010	3.060	✓		V&N	
C 2.52	H-0.030	2.50	✓		V&N	
D 0.060	+/-0.030	0.00	✓		V&N	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>mt. ml</i>	Audited by: <i>E. Stork</i>	Prototype Approval:	N/A
Date: 07 04 26	Date: 07 04 24	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

